



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3041-3**Job Sheet 205635**

Part No: D3041-3

Job Qty: 25 pcs

Part Name: Clamp



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/15/20

Job Tracking No:

Due Date: 4/10/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: A 01.07.11 New Issue SM/EC

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
10	Purchasing	25 pcs		4/9/20	0.00	0.00				
120	Packaging 2-1 - Receive - B4B	25 pcs		4/9/20	0.00	0.00	Packaging 2 - 1 - B4B			He APR 16 2020
							Packaging 2 - 2 - E4B			
							Packaging 2 - 3 - B4B			
							Packaging 2 - 5 - B4B			He APR 16 2020
							Packaging 2 - 4 - B4B			
							Packaging 2 - 6 - B4B			
							Packaging 2 - 7 - B4B			
							Packaging 2 - 8 - B4B			
							Packaging 2 - 9 - B4B			
							Packaging 2 - 10 - B4B			
							Packaging 2 - 11 - B4B			
							Packaging 2 - 12 - B4B			
							Packaging 2 - 13 - B4B			
							Packaging 2 - 14 - B4B			
							Packaging 2 - 15 - B4B			
							Packaging 2 - 16 - B4B			
							Packaging 2 - 17 - B4B			
							Packaging 2 - 18 - B4B			
							Packaging 2 - 19 - B4B			
							Packaging 2 - 20 - B4B			
							Packaging 2 - 21 - B4B			
							Packaging 2 - 22 - B4B			
							Packaging 2 - 23 - B4B			
							Packaging 2 - 24 - B4B			
							Packaging 2 - 25 - B4B			
							Packaging 2 - 26 - B4B			
							Packaging 2 - 27 - B4B			
							Packaging 2 - 28 - B4B			
							Packaging 2 - 29 - B4B			



Container No: S271024



Part: D3041 - 3
Job No: 205635
Serial No/Batch: S271024
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/16/20



Container No: S271024



Part: D3041-3

Job No: 205635

Serial No/Batch: S271024

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 04/16/20

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					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
130	QC 6	25 pcs	4/9/20	0.00 0.00	QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	40
					QC 6 - 40	APR 20 2020 9-89
					QC 6 - 81	
131	Handfinish - 1-1 Chemical-B4B	25 pcs	4/9/20	0.00 0.83	Handfinish - 1 - 1 - B4B	BEB 20-04-23
132	QC 7	25 pcs	4/9/20	0.00 0.00	QC 7 - 10	20-04-28
133	Powdercoat - 1 White Gl(A)-B4B	25 pcs	4/9/20	0.00 0.42	Powdercoat - 1 - B4B	20-04-28
134	QC 3	25 pcs	4/9/20	0.00 0.00	QC 3 - 10	20-4-29
135	Small Fab - 2 - B4B	25 pcs	4/10/20	0.00 1.48	Small Fab - 1 - B4B	DAS
					Small Fab - 2 - B4B	58
					Small Fab - 3 - B4B	9-89
					Small Fab - 4 - B4B	MAY 08 2020
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					Small Fab - Various 1 - B4B	
145	QC 5	25 pcs	4/10/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	DAS
					QC 5 - 40	MAY 12 2020 40
					QC 5 - 61	9-89
					QC 5 - 81	
180	Packaging 3-1 - Stock - B4B	25 pcs	4/10/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	DAS
					Packaging 3 - 5 - B4B	28
					Packaging 3 - 6 - B4B	9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	

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				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
190 QC 21 - SA	25	4/10/20	0.00 0.00	QC 21 - SA - 21	MAY 13 2020
	pcs			QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21

Part Op 110 - Outsource process - Machining Issue P/O to Metec :POHB045579 Machine, ALUMINE, POWDER COAT as per
 Descriptions: dwg C of C is required ATTN: MASK BEARING HOLE, PRIOR TO POWDER COATING

120 - Receive & Inspect for Damage & Mat'l Certs Ensure C of C is attach

130 - QC6- All purchased or subcontracted products

131 - Chemical Conversion Coat per QSI005 4.1

132 - QC7-Inspect Chemical Conversion Coat

133 - START TIME: 6:45 OVEN TEMPERATURE: 320° FINISH TIME: 1:15

134 - QC3- Inspect Part Finish Standard Process

135 - Small Fab Memo 1- Press 02611 bearing into lug as per Dwg 03041 using DT 9472 2- Stake bearing into place as per Dwg D3041 using DT9456 3-Touch up stake marks with white iron paint

145 - QC5- Inspect part completeness to step on W/O

180 - Identify as per dwg & Stock Location:

190 - QC21- Final Inspection - Work Order Release

Patrick Lussier

PO Details

Metec Metal Technology Inc. (mem001-vc)



PO No: POHB045579

Line No: 2

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	2.6050 ft (1042 ea)	110-Purchasing	5101247
D3041-3P	Clamp	25 pcs (1 ea)	110-Purchasing	5270021
D2611	Bearing	25 pcs (1 ea)	135-Small Fab - 2 - B4B	5247186

Job Allocations

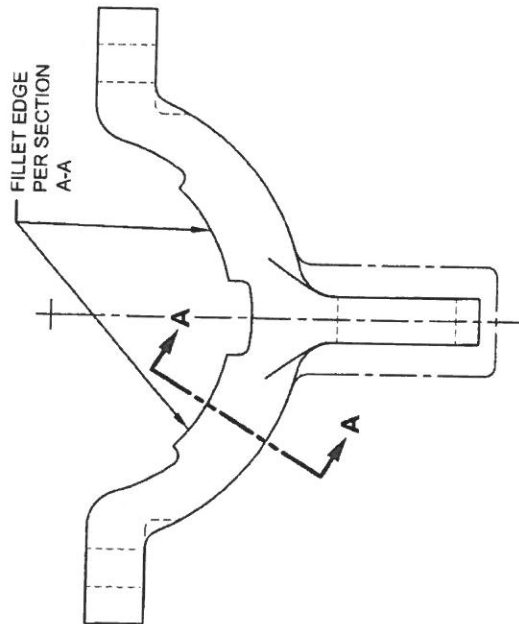
Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2423	3	539	0
	D3041-3P	25	0	0
135-Small Fab - 2 - B4B	D2611	25	258	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	4.200Inches $\pm$ 0.030	4.230 4.170		
2	Clamp	0.240Inches $\pm$ 0.010	0.250 0.230		
3	Clamp	1.190Inches $\pm$ 0.010	1.200 1.180	Radius	
4	Clamp	0.400Inches $\pm$ 0.010	0.410 0.390		
5	Clamp	0.250Inches $\pm$ 0.010	0.260 0.240	Radius	
6	Clamp	0.313Inches $\pm$ 0.010	0.323 0.303		
7	Clamp	0.063Inches $\pm$ 0.010	0.073 0.053	Radius	
8	Clamp	1.190Inches $\pm$ 0.030	1.220 1.160		
9	Clamp	1.124Inches $\pm$ 0.010	1.134 1.114		
10	Clamp	0.563Inches $\pm$ 0.010	0.573 0.553		
11	Clamp	0.562Inches $\pm$ 0.010	0.572 0.552	Radius	
12	Clamp	0.812Inches + 0.000 - 0.001	0.812 0.811	Diameter	
13	Clamp	2.071Inches $\pm$ 0.010	2.081 2.061		
14	Clamp	0.750Inches $\pm$ 0.010	0.760 0.740		
15	Clamp	0.375Inches $\pm$ 0.010	0.385 0.365		
16	Clamp	0.338Inches $\pm$ 0.010	0.348 0.328	Radius	
17	Clamp	3.450Inches $\pm$ 0.010	3.460 3.440		
18	Clamp	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter	
19	Clamp	0.375Inches $\pm$ 0.010	0.385 0.365	Radius	
20	Clamp	0.375Inches $\pm$ 0.010	0.385 0.365		
21	Clamp	0.032Inches $\pm$ 0.010	0.042 0.022	Radius	
22	Clamp	0.250Inches $\pm$ 0.010	0.260 0.240	Radius	

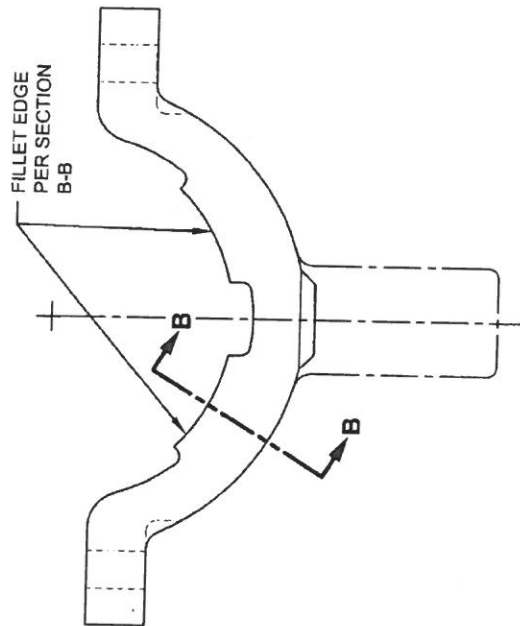
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DRAWING NO. D3041	TITLE CLAMP	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 115	CHECKED		MFG. APPR.	APPROVED		DE APPR.	
DATE 09.03.04	DATE 09.03.12		DATE 09.03.12	DATE 09.03.13		DATE 09.03.13	

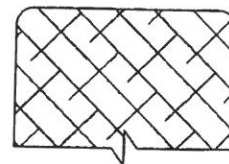
ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



D3041-1 CLAMP
D3041-3 CLAMP



D3041-5 CLAMP
D3041-7 CLAMP



SECTION A-A
SCALE 2X

SECTION B-B
SCALE 2X

RELEASED
09/07/07

SEE PAR 122 FOR FURTHER DETAILS

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No.

Route update only

Job: _____		DISPOSITION		DEPARTMENT/PROCESS		Engineering							
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Water Jet ☐ Supplier ☐ Quality ☐					
Date:	Sequence #:	QTY Affected:		MRB (QSI042)									
Description Work Order Deviation				Disposition									
Root Cause				FAULT CATEGORY									
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐						Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Other/Details:													
Completed By				Lead hand / Supervisor									
QC / QA Coordinator													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB045579



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045579

PO Date: 1/15/20

Due Date: 4/10/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Lussier, Patrick
Phone: 613-632-5200 Ext: 276
plussier@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Items														
Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	205634	D3041-1P	D3041 Rev.C			Clamp : Various STC's receive pcs	Firmed X25	-	4/10/20	25 Ea	0 Ea	25 Ea	\$14.41/Ea	\$860.25
Line Item Note *** UNPAINTED ***														
2	205635	D3041-3P	D3041 Rev.C			Clamp : Various STC's receive pcs	Firmed X25	-	4/10/20	25 Ea	0 Ea	25 Ea	\$14.41/Ea	\$360.25
Line Item Note *** UNPAINTED ***														
3	205636	D3041-5P	D3041 Rev.C			Clamp : Various STC's receive pcs	Firmed X25	-	4/10/20	25 Ea	0 Ea	25 Ea	\$15.75/Ea	\$393.75
Line Item Note *** UNPAINTED ***														
4	205637	D3041-7P	D3041 Rev.C			Clamp : Various STC's receive pcs	Firmed X25	-	4/10/20	25 Ea	0 Ea	25 Ea	\$15.75/Ea	\$393.75
Line Item Note *** UNPAINTED ***														
													Grand Total:	\$1,508.00

DAS
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9-89

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Dart Aerospace Ltd.
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K6A 1K7
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Tel (613) 632-5200

PURCHASE ORDER

POHB045579



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

Patrick Lussier

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

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20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
25	DART-D3041- 1P- UNPAINTED	Clamp	C	S101247	-	HB045579
25	DART-D3041- 3P- UNPAINTED	Clamp	C	S101247	-	HB045579

MATERIAL: supplied by DART

DAS
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9-89

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, April 16, 2020



www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill Dart Aerospace Ltd.

To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.

To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: **27171**
Shipment Date: 16-Apr-2020
Ship Via: Pick up at METEC
Order Number: 4526
Order Date: 01/16/2020

Customer Code: DART
Phone: (613) 632-9577
PO Number: **FOHB045579**
Terms: Net 60 Days

Quantity

Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision	Job Number
5	25	25	0	0	EA	DART-D3041-1P-UNPAINTED Clamp	C	4526-05
6	25	25	0	0	EA	DART-D3041-3P-UNPAINTED Clamp	C	4526-06

RECEIVED

APR 16 2020

DART AEROSPACE LTD.

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Heather Nijm

Packing Clerk's Signature
Metec Metal Technology Inc

Received In Good Order By
Dart Aerospace Ltd.